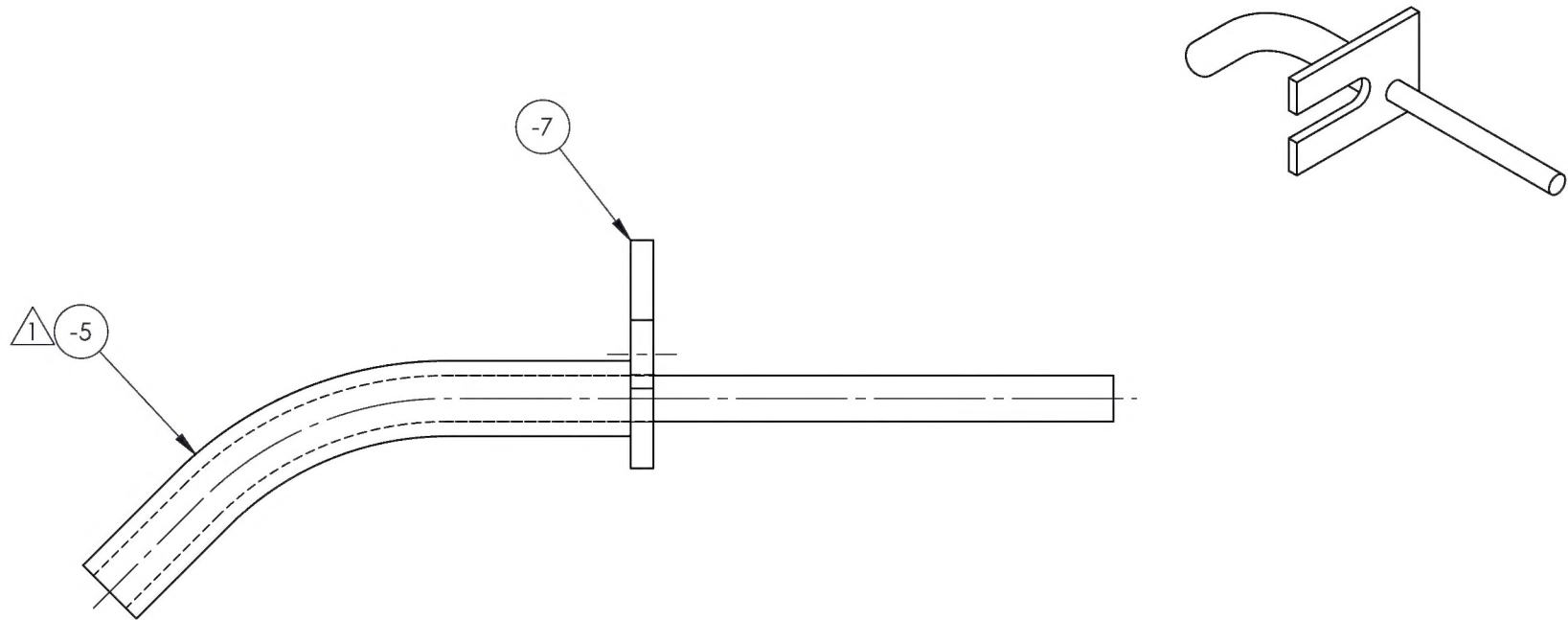


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		UPDATED TITLEBLOCK & REVISION BLOCK, ADDED ENGRAVE NOTE, CH'D TOOL NO. TO RB23008710, ADDED FRONT VIEW SHEET 1.	6/17/2009	RJC	
B		-3 CH'D BOM P/N WAS 23457/ESP-MW-3/16 BK (NORVAC) IS MCMASTER-CARR #8195K21.	10/21/2013	RJC	RJC
2	16-0247	UPDATED TO NEW STANDARD. -1 CH'D MAT'L WAS S.S. IS 304 S.S. ADDED DIMS .186, Ø.128 +.005-.000, WAS R.093 IS R.093±.010. -3 ADDED DRAWING. -7 ADDED TO BOM, ADDED DRAWING.	12/21/2016	DPD	JAG



NOTE:

1 INSTALL -5 INSULATOR AS SHOWN.

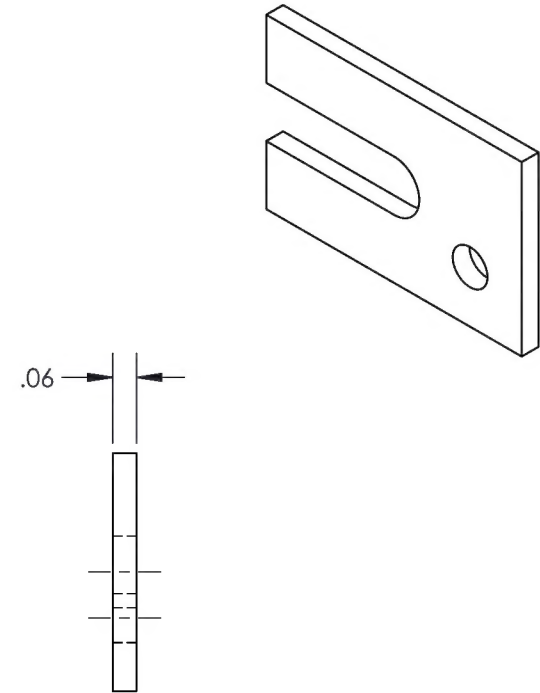
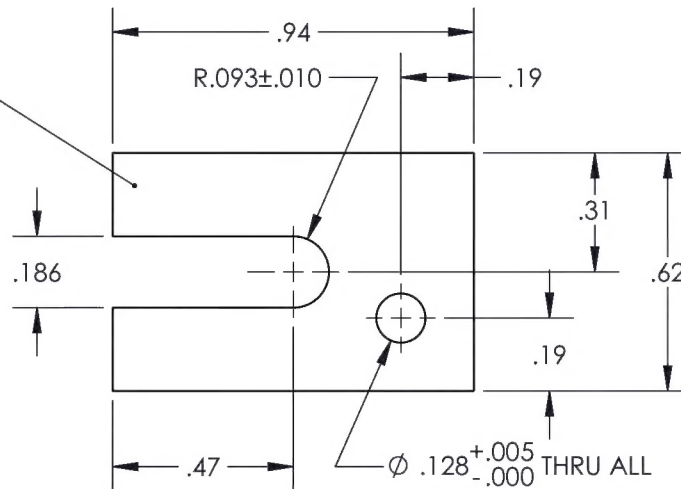
<b>DART</b> AEROSPACE																	
TITLE <b>FIXTURE: GAS PRODUCER ROTOR</b>																	
DWG NO. <b>RB23008710</b>	REV <b>2</b>																
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± .5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125✓</td> </tr> <tr> <td colspan="2">1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td colspan="2">2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td colspan="2">3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± .5°		.X ± .1 SURFACES = 125✓	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
MAT'L	UNLESS OTHERWISE SPECIFIED																
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FINISH	.XXX ± .005 FRACTIONS ± 1/8																
SPEC	.XX ± .01 ANGLES ± .5°																
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<table border="1"> <tr> <td>DRAWN BY:</td> <td>COLE</td> </tr> <tr> <td>CHECKED:</td> <td>CLOUGH</td> </tr> <tr> <td>OPPS APPR:</td> <td>ANDERSON</td> </tr> <tr> <td>QA APPR:</td> <td>LINDSAY</td> </tr> <tr> <td>APPROVED:</td> <td>GILBERT</td> </tr> </table>		DRAWN BY:	COLE	CHECKED:	CLOUGH	OPPS APPR:	ANDERSON	QA APPR:	LINDSAY	APPROVED:	GILBERT						
DRAWN BY:	COLE																
CHECKED:	CLOUGH																
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APPROVED:	GILBERT																
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SCALE	2:1																
DATE	9/15/2003																
SHEET 1 OF 4																	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
	1		-1		TAB	304 S.S.		2
	1		-3		ROD	BRASS		3
		B/O	-5	1	INSULATOR	HEAT SHRINK	Ø3/16 MW HEAT SHRINK TUBING, BLACK (MCMASTER-CARR #8195K21)	1
	X		-7	1	WELDMENT			4
	ASSY -7							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0247	-1 CH'D MAT'L WAS S.S. IS 304 S.S. ADDED DIMS .186, Ø.128 +.005-.000, WAS R.093 IS R.093±.010.	12/21/2016	DPD	JAG

ENGRAVE T/N, S/N  
"MADE IN USA"



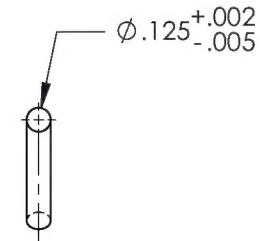
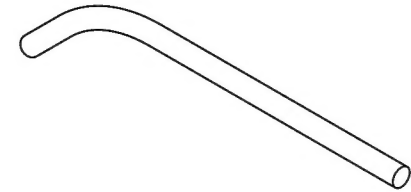
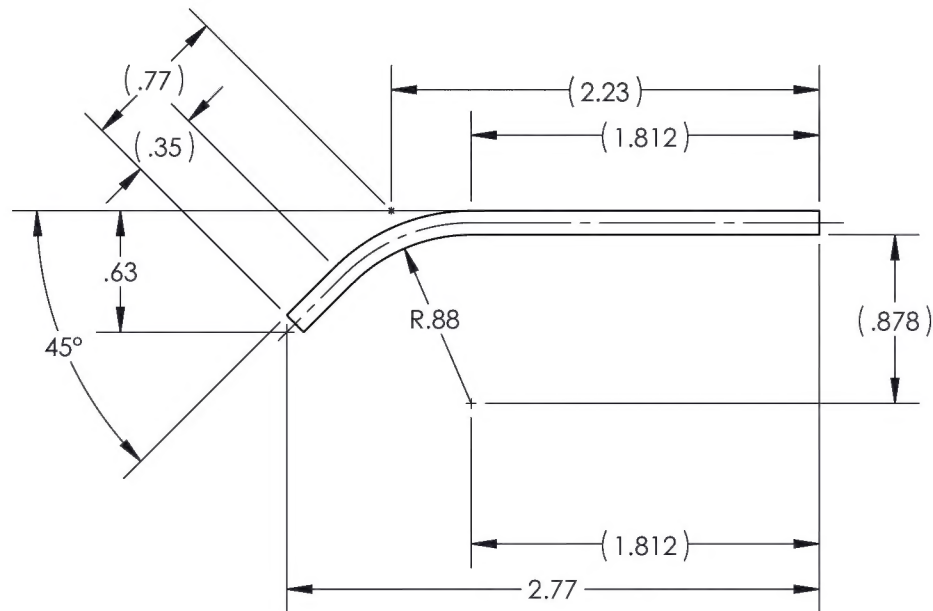
(-1)

TAB

<b>DART</b> AEROSPACE	
TITLE <b>FIXTURE: GAS PRODUCER ROTOR</b>	
DWG NO. <b>RB23008710-1</b>	REV <b>2</b>
MAT'L 304 S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 2:1	DATE 9/15/2003
	SHEET 2 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0247	-3 ADDED DRAWING.	12/21/2016	DPD	JAG

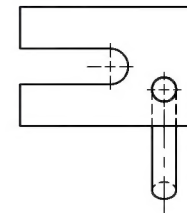
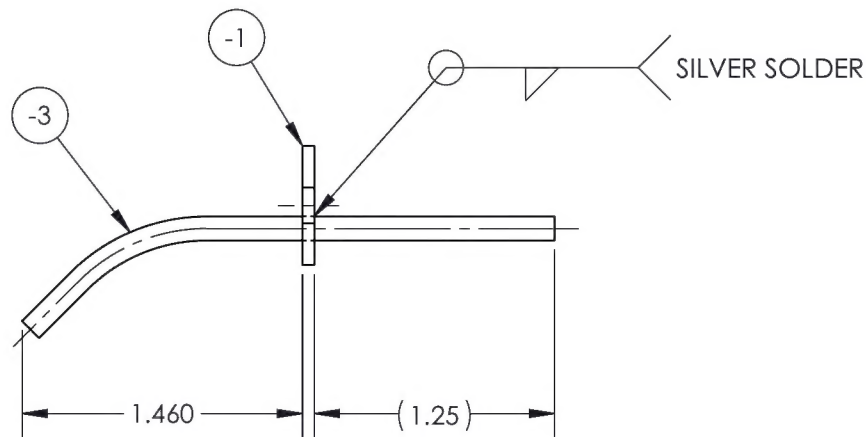
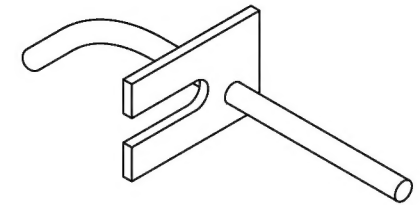


(-3)  
ROD

<b>DART</b> AEROSPACE	
TITLE <b>FIXTURE: GAS PRODUCER ROTOR</b>	
DWG NO. <b>RB23008710-3</b>	REV <b>2</b>
MAT'L BRASS	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	ROLLS ROYCE 250-C47B
SCALE 1:1	DATE 9/15/2003
	SHEET 3 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0247	-7 ADDED TO BOM, ADDED DRAWING.	12/21/2016	DPD	JAG



NOTE:  
USE FIXTURE RB23008710-7-F.

<b>DART</b> AEROSPACE	
TITLE <b>FIXTURE: GAS PRODUCER ROTOR</b>	
DWG NO. <b>RB23008710-7</b>	REV <b>2</b>
MAT'L REAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	ROLLS ROYCE 250-C47B
SCALE 1:1	DATE 9/15/2003
SHEET 4 OF 4	

(-7)  
WELDMENT